

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014973**Date Inspected:** 06-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 8CE ~ 9AE & 9AE ~ 9BE

This QA Inspector performed Joint Inspection with ABF Survey Team for the Skin Flatness between Segment 8CE~9AE and 9AE ~ 9BE (Shop Segment Splice) between Panel Point (PP) 71 to 72 and PP 73 to PP 74

(Counter Weight side at B1 and B2 locations) and South (Cross Beam side at B3 and B4 Locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

(Counter Weight side at T1 location) and South (Cross Beam side T2 Location) at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

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The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8AW to 8BW (T-Ribs) Caltrans QA Survey Inspection

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Individual Inspection for the T-Ribs to T-Ribs between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 64 and PP 65 North(Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8BW to 8CW (T-Ribs) Caltrans QA Survey Inspection

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Individual Inspection for the T-Ribs to T-Ribs between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 North(Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8CE to 9AE (T-Ribs) Caltrans QA Survey Inspection

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Individual Inspection for the T-Ribs to T-Ribs between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 North(Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
